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D350-591-213
Job Sheet 186058



Part No: D350-591-213

Job Qty: 4 ea

Part Name: Heli-Access-Step™ LH - High Gear, Short Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/9/18

Job Tracking No:

Due Date: 11/30/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV H IPP Rev:B 05.10.14 Modified step 10 KJ/EC IPP Rev:C 06-06-19 Added D2732-030 AS PER DSI9294 JLMIPP REV:D 14.12.17 ADD DSI9712-011 DD VERF:JLM IPP Rev:C 06-06-27 Revised as per DSI9340 JLM IPP Rev:D 10.03.17 incorporate seq 180 to 200 remove qc5 DD verified by:JLM IPP Rev:E 10.11.15 update qty on AN4-11A DD verf:EC IPP REV:F 16.03.16 IIN REV:H DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	11/30/18	11/30/18	0.00	0.00	Start Up Stores/Pkg-2		NOV 13 2018
270	Packaging	4 pcs	11/30/18	11/30/18	0.00	0.00	Packaging1-3	NOV 22 2018	DAS 46
280	QC	4 pcs	11/30/18	11/30/18	0.00	0.00	QC4	NOV 22 2018	DAS 46
290	Packaging	4 pcs	11/30/18	11/30/18	0.00	0.00	Packaging3-1	NOV 22 2018	DAS 9-89
295	DC	4 pcs	11/30/18	11/30/18	0.00	0.00	DC		NOV 22 2018
300	QC21-FG	4 Ea	11/30/18	11/30/18	0.00	0.00	QC21		NOV 22 2018

Part Op 290 - Identify and pack for shipping as per PPP D350-591-213
Descriptions: 295 - Photocopy bluefile and type labels as per PPP D350-591-213 CHG005

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-35A	Bolt	8 Ea (2 ea)	90-Start up Operation	508930727 510132921
AN4-15A	Bolt	16 Ea (4 ea)	90-Start up Operation	5107730
AN5-36A	Bolt	8 Ea (2 ea)	90-Start up Operation	5079504
D2230-3	Mounting Lug	8 Ea (2 ea)	90-Start up Operation	5117679
D2618	Bushing	8 Ea (2 ea)	90-Start up Operation	5089996
D2732-030	Rubber Cushion - 3"	16 Ea (4 ea)	90-Start up Operation	5112723
D3235-1	Mounting Lug	8 Ea (2 ea)	90-Start up Operation	5113205
D3338-1	Mounting Lug	4 Ea (1 ea)	90-Start up Operation	5104230
MS21042L3	Nut	8 Ea (2 ea)	90-Start up Operation	5094592
MS21042L4	Nut	24 Ea (6 ea)	90-Start up Operation	5107736
MS21042L5	Nut	8 Ea (2 ea)	90-Start up Operation	5093562
NAS1149D0363J	Washer	16 Ea (4 ea)	90-Start up Operation	5075293
NAS1149D0463J	Washer	48 Ea (12 ea)	90-Start up Operation	5092780
NAS1149D0563J	Washer	16 Ea (4 ea)	90-Start up Operation	5050033
AN4-16A	Bolt	16 Ea (4 ea)	90-Start up Operation	5122284
D3078-041	Step Assembly, Hi Short LH	4 Ea (1 ea)	270-Packaging	5122924

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :		Step #:		QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation				Disposition			
DART Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com Container No: S127284 Part: D350 - 591 - 213 Job No: 186058 Serial No/Batch: S127284 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: TC STC SH92 - 6 Issue 1d4eFAA138TC SH967NE Er Eq Ha Interna Tribal I LUA Substation Past Expiry Date Misidentified				Completed By			
				Lead hand / Supervisor Approval Verification			
				QC / QA Coordinator Approval			
				FAULT CATEGORY			
☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter				☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes			
				☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center			
				☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence			
Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐				OTHER : ☐			

90-Start up Operation

AN3-35A

8

261

0

AN4-15A

16

323

0

AN4-16A

16

476

0

AN5-36A

8

124

0

D2230-3

8

88

0

D2618

8

189

0

D2732-030

16

57

0

D3235-1

8

149

0

D3338-1

4

40

0

MS21042L3

8

2,035

0

MS21042L4

24

2,463

0

MS21042L5

8

471

0

NAS1149D0363J

16

2,153

0

NAS1149D0463J

48

3,231

0

NAS1149D0563J

16

1,404

0

270-Packaging

D3078-041

4

4

0

Part Specifications

Specifications could not be found.

Plex 11/9/18 8:42 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
Root Cause				FAULT CATEGORY					
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due	☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter	☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center	☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence				
OTHER :									

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	<i>Hel-Access-Step™</i> , Short Step – High Skid, LH
	X					D350-591-214	<i>Hel-Access-Step™</i> , Short Step – High Skid, RH
		X				D350-591-215	<i>Hel-Access-Step™</i> , Short Step – Low Skid, LH
			X			D350-591-216	<i>Hel-Access-Step™</i> , Short Step – Low Skid, RH
				X		D350-591-311	<i>Hel-Access-Step™</i> , Long Step – High Skid, LH
					X	D350-591-312	<i>Hel-Access-Step™</i> , Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.

REFERENCE ONLY

REFERENCE UNIT

REFERENCE UNIT

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-591 REV. 3
REF TCCA STC: SH92-6
REF FAA STC: SH967NE

REFERENCE ONLY

1.0 Purpose

It has come to DART's attention that it may be difficult to fasten the D350-591-133 Aft Maintenance Step and D350-591-213/-214 Heli-Access-Step Installations to the forward crosstube due to variations between crosstubes. For this reason, DART is adding the D3338-1 Mounting Lug to the D350-591-133 Aft Maintenance Step and D350-591-213/-214 Heli-Access-Step Kits at CHG 004 and later.

For D350-591-133 Aft Maintenance Step and D350-591-213/-214 Heli-Access-Step Kits at CHG 003 and earlier, DSI 9712-011 Mounting Lug Kit can be procured from DART. The kit contains all parts to upgrade a single step kit.

2.0 Installation

- 2.1 It is acceptable to install the D3338-1 Mounting Lug in lieu of the D2230-1 Mounting Lug as required to reduce the gap between step and the forward crosstube in accordance with the figures of this service instruction.
- 2.2 The height to set up the D350-591-133 Maintenance Step has been revised from 7.0in to 6.0in $\pm$ 1.0in to provide more flexibility. See sheet 2 of this service instruction.
- 2.3 In all other respects, install the D350-591-133 Aft Maintenance Step and D350-591-213/-214 Heli-Access-Steps in accordance with Section 3.1 of Installation Instructions D350-591 or Section 32.1 of Instructions for Continued Airworthiness ICA-D350-591.

3.0 Parts List Change

The following additional part is provided with D350-591-133 Aft Maintenance Step and D350-591-213/-214 Heli-Access-Steps at CHG 004:

Qty -133	Qty -213	Qty -214	Part Number	Description
X			D350-591-133	Heli-Access-Step™, Aft Maintenance Step
	X		D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
		X	D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
1	1	1	D3338-1	MOUNTING LUG (ADD)

4.0 DSI 9712-011 Mounting Lug Kit Parts List

For existing D350-591-133 Aft Maintenance Steps and D350-591-213/-214 Heli-Access-Steps at CHG 003 or earlier, one DSI 9712-011 kit upgrades one step installation:

Qty -011	Part Number	Description
X	DSI 9712-011	Mounting Lug Kit
1	D3338-1	MOUNTING LUG

REFERENCE ONLY

5.0 Weight and Balance

There is a negligible weight change associated with this modification.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 14.12.04
CERT. NO.: SH92-6
ISSUE NO.: 11

A	NEW ISSUE	MB	14.10.22
REV.	DESCRIPTION	BY	DATE
DESIGN	 DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. A SHEET 1 OF 3	
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED	 DSI 9712	TITLE INSTALLATION OPTION NTS	
DE APPR.			
DATE	14.10.22	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G OR EARLIER
AND
INSTRUCTIONS OF CONTINUED AIRWORTHINESS ICA-D350-591 REV. 2 OR EARLIER

REF CANADIAN STC: SH92-6

REF FAA STC: SH967NE

For D350-591-213/-214/-215/-216 steps, customers have the option of installing D2732-030 cushion under the clamps to accommodate varying crosstube diameters and to improve fit, as indicated in Installation Instructions D350-591. This Service Instruction adds longer AN4-16A bolts to the parts list to allow installation of these cushions. See Figure 1 on sheet 2 of this service instruction for reference. Installation of the D2856-400-720 Abrasion Strips per Installation Instructions D350-591 is not required when the cushions are installed.

For D350-591-213/-214/-215/-216 steps at CHG 003, the parts list of D350-591 Rev. G and ICA-D350-591 Rev. 2 is amended as follows:

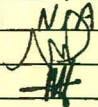
ADD:

Qty -213	Qty -214	Qty -215	Qty -216	Part Number	Description
X				D350-591-213	Heli-Access-Step ™, Short Step – High Skid, LH
	X			D350-591-214	Heli-Access-Step ™, Short Step – High Skid, RH
		X		D350-591-215	Heli-Access-Step ™, Short Step – Low Skid, LH
			X	D350-591-216	Heli-Access-Step ™, Short Step – Low Skid, RH
4	4	4	4	AN4-16A	BOLT

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: 
D. SHEPHERD (DE # 02)

DATE: 09.08.05
CERT. NO.: SH92-6
ISSUE NO.: 11

A	NEW ISSUE	RF	09.08.05
REV.	DESCRIPTION	BY	DATE
DESIGN	92	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	UP	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9472	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BOLT ADDITION	NTS
DATE	09.08.05	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Change Record

PAGE 1 OF 1

Part Number: D350-591-213/-213GB/-214/-214GB

Description: HELI-ACCESS STEP, HIGH SKID, SHORT STEP, LH/RH

[illegible]

